

31.75

Dart Aerospace Ltd.

Date: Thursday, 19/03/2009 4:30:49 PM
User: Julie Dawson

Process Sheet

SPUT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
Job Number : 46614
Estimate Number : 11119
P.O. Number :
This Issue : 19/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 42946
Written By :
Checked & Approved By : J.D. 09.03.19
Comment : Est: A 01.07.11 New Issue SM
est B 07.04.09 rev.c dwg EC

Part Number : D30411
Drawing Number : D3041 REV.C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 06/04/2009 Qty: 27 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



114 4.57 f(s)



Comment: Qty.: 0.0875 f(s)/Unit Total: 3.4986 f(s)

Lug Extrusion
(D2423)

Batch: 1345800

SA 09/03/24 4.57 ft

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

SA 09/03/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio FA153

SP 09/03/27

M.A 09/03/28

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/03/28

5.0 QC8 SECOND CHECK


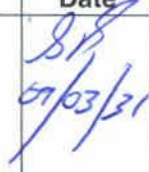
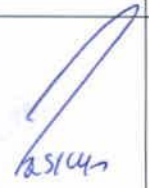


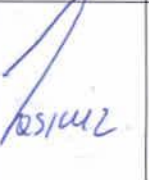



Comment: SECOND CHECK

SA 09/03/31

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3041-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/04/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46614</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/28	3.0	1 part scrap The Y origin on last app. has not been taken properly -machinist error - machinist in training		Scrap / no replace.	 09/03/31	J.F. 09/03/31		
09/03/28	3.0	1 part scrap ø.8110 - .8115 is ø.814 material chip build up R.C. process.		change reamer ø.8110 for ø.8105 scrap. no replace.	M.A. 09/03/28	J.F. 09/03/31		

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 46614

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 09/03/31 (40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FD 09/03/31 counter (40)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

START TIME:

7:20

OVEN TEMPERATURE:

320°

FINISH TIME:

7:50

FD 09/04/09 (40)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-04-09

(40)

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty

1

Part Number

D2611

Description

Bearing

Batch

B42597 9X

B42597 4X

18

lala... 19/4/9

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

FF 09-04-09 (13)

**PLEASE SEE JASON BEFORE PRESSING
BEARINGS FOR NEW TOOLING **

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 46614

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S02104/09 (x13)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPP 4657H*

SS c9104/09 (x13)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mr 09-04-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4664 4664
Description: CLAMP		Part Number: D3041-3
Inspection Dwg: D3041 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

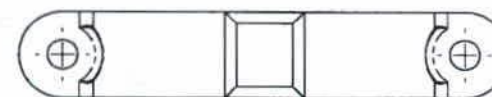
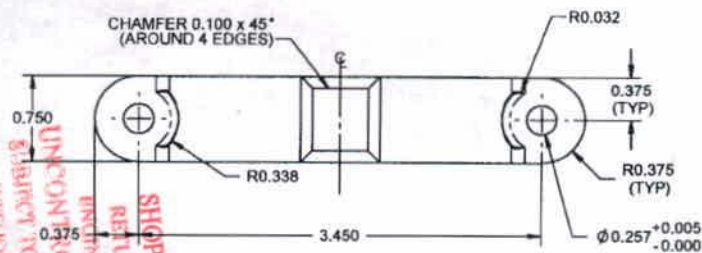
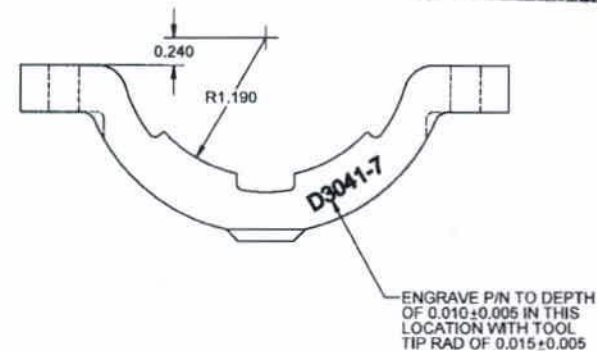
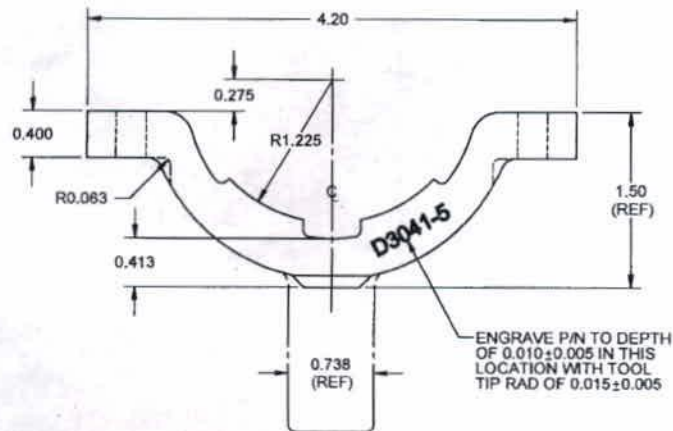
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/- .030	4.201	✓			
0.275	+/- .010	0.272	✓			
R1.225	+/- .010	R1.225	✓			
0.400	+/- .010	0.397	✓			
R0.250	+/- .010	R0.250	✓			
0.313	+/- .010	0.315	✓			
R0.063	+/- .010	R0.063	✓			
1.19	+/- .030	1.19	✓			
1.124	+/- .010	1.128	✓			
0.563	+/- .010	0.563	✓			
R0.562	+/- .010	R0.562	✓			
Ø0.8115-0.8110	N/A	0.8110	✓			
2.071	+/- .010	2.070	✓			
0.750	+/- .010	0.750	✓			
0.375	+/- .010	0.378	✓			
R0.338	+/- .010	R0.338	✓			
3.450	+/- .010	3.449	✓			
Ø0.257	+0.005 / -0.000	Ø0.259	✓			
R0.375	+/- .010	R0.375	✓			
0.375	+/- .010	0.376	✓			
R0.032	+/- .010	R0.032	✓			
R0.250	+/- .010	R0.250	✓			

Measured by: H.A	Audited by: 	Prototype Approval:	N/A
Date: 09/03/20	Date: 09/03/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

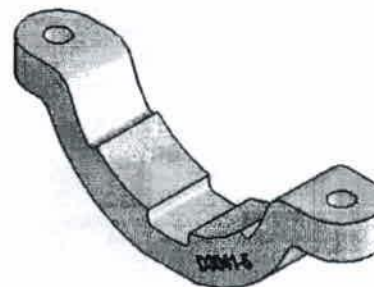
RELEASED

06.11.17



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

D3041-5 CLAMP



NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ

DESIGN 90	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1	

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